Quality Control

Page 1

D4173-3 Item ID: Accept Setup Start PRELIM Revision ID: Pod Radalt Doubler Item Name: Stop Start Qty: 3,00 Start Date: 9/8/2010 Cust Item ID: Required Date: 9/13/2010 Req'd Qty; 3.00 Customer: Reference: Run Start Date: 10-9-08 Process Plan: Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Tool ID Tool# Plan Reject Accept Reject Insp. Work Center ID Description Run Hours Qty Code Qty Number Stamp Draw Nbr Revision Nbr 110.08:18 D4173 100 0.00 1310.9-13 Waterjet Memo Paz same dim as Pal FLOW CNC Waterjet 1-Cut as per Dwg Dwg Rev: PA1 Prog Rev: 2-Deburr if necessary 110 QC2- Inspect parts off machine FAI/FAIB 0.00 B10-9-13 QC 0.00 Memo

W/O:			WC	ORK ORDER CHANGES	3				
DATE	STEP	PRO	ROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
									_
Part No	:	PAR #:	Fault Cate	gory: I	NCR: Yes	No DQ	A:	_ Date: _	
Resolution:		esolution:	Disposition: QA			osed:		Date: _	
NCR:			WORK ORD	ER NON-CONFORMAN	CE (NCF	R)			
DATE	STEP	Description of NC		Corrective Action Section B			ation	Approval	Approval
DATE		Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector

Work Order ID 61880

Wednesday, September 08, 2010 3:26:58 PM



Page 2

Item ID:

D4173-3

PRELIM

Revision ID: Item Name:

Pod Radalt Doubler

Start Date:

9/8/2010

Start Qty: 3.00

Required Date: 9/13/2010

Req'd Qty: 3.00



Accept



Setup Start

Stop



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

QC:

Date:

SPC (Y/N):

Tool ID

Date:

Tool#

Plan

Code

Accept

Qty

Reject

Qty

Reject

Stamp

Number

Sequence ID/ Work Center ID

120

Quality Control

Operation Description

QC8- Inspect parts - second check

Memo

Set Up/ Run Hours

0.00 - inspected to PA)

0.00 BR 10-9-14.

130

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

Memo

0.00

Powdercoat

Powder Coating

Grey Sandtex(Ref.4.3,5.6) per QSI005 4.3

M112588

Memo

Start Time: 2 45pm Oven Temperature: 320°1= Finish Time: 3:155...

0.00) Il 10/09/15

140

Dart A	Aerospace I	Ltd
Duit /	TOI OSPUOCI	

W/O:			WO	RK ORDER CHANGES	3					
DATE	STEP	PRO	OCEDURE CHAP	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Category: NCR: Yes No DQA					QA: Date:		
			Disposition: Q/							
NCR:			WORK ORDE	R NON-CONFORMAN	CE (NCF	1)				
DATE	OTER	Description of NC Section A	Corrective Action Section B			Verific	cation	Approval	Approval	
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector	

Work Order ID 61880

Wednesday, September 08, 2010 3:26:58 PM



Page 3

Item ID:

D4173-3

Revision ID:

PRELIM

Item Name:

Pod Radalt Doubler

Start Date:

9/8/2010

Start Qty: 3.00

Required Date: 9/13/2010

Req'd Qty: 3.00



Accept



Setup Start

Stop



Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Cust Item ID:

Customer:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID

150

Quality Control

Operation Description

QC3- Inspect Part Finish

Set Up/ Run Hours

Tool ID

Tool # Plan Accept Qty Code

Reject Qty

Reject Number

Insp. Stamp

Memo

Digory Sidorlie (co)

0.00 - inspectos to Pal

Packaging

Packaging

Identify as per dwg & Stock Location:

QC21- Final Inspection - Work Order Release

Memo

0.00

ET 10-10-01

Quality Control

Memo

0.00

0.00

10/10/04 A) phorog

POSITIVE RECALL EFFECTIVE 10-09.3

RELEASED_

	ospace								
W/O:			WORK ORDER CHANGES						
DATE	STEP	PRO	OCEDURE CHAP	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Categ	gory:	NCR: Yes	No DQ	A:	Date:	
Resolution:			Disposition	QA: N/C Cld	sed:		Date: _		
NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR)			
		Description of NC Section A	Corrective Action		on B	Verific	cation	Approval	Approval
DATE	STEP		Initial Chief Eng	Action Description Chief Eng	Sign & Date		on C	Chief Eng	QC Inspector

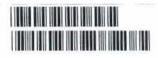
Picklist Print

Wednesday, September 08, 2010 3:27:07 PM

Work Order ID: 61880

Parent Item: D4173-3

Parent Item Name: Pod Radalt Doubler



Start Date: 9/8/2010

Start Qty: 3.00

Required Date: 9/13/2010

Required Qty: 3.00

Comments:

IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	104.9340	0.4935	1.558421			
THE PARTY OF THE PARTY OF THE PARTY.											B10-0	2-13	

6061-T6 .063 Sheet

Page 1

W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CHA	CEDURE CHANGE			Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	orv.	NCB: Yes	No DO		Date:	,
		solution:							
	110			ER NON-CONFORMA				_ Date	
NCR:					NCE (NCH	,			
DATE	STEP	Description of NC		Initial Action Description			ation	Approval	Approval
		Section A	Chief Eng			Sign & Section C		Chief Eng	QC Inspector

Route Bom/AKF

15

1.900 7 220 7.024 1.300 3.512 PITCH 0.288 330 0.363 TYP TYP 180 0 0 1,378 R0.05 0 4 PL 4.620 4.620 7.38 5.63 0 2.310 PITCH 6 \oplus 0 D4173-3 Ø0,201 88.0 0 0 BXXXXX TYP .100 0.063 R0.93 REF 0.88 4 PL 9.63

B10-9-09

D4173-3 POD RADALT DOUBLER

PRELIMINARY ISSUE 10.09.08

NOTES: 1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.963 THICK PER QQ-A-250/11 OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209 REF. DART SPEC. M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

3) TOLERANCES: PER DART "QSI 018 UNIESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHAPP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: PER QSI 044 6.1

7) WEIGHT: 0.16 lbs REF. DART SPEC, M6061T6S,063

DESIGN	DART AFROSPAC	DART AEROSPACE LTD					
DRAWN	HAWKESBURY, ONTARIO,						
CHECKED	DRAWING NO.	REV. PA1					
MFG, APPR.	D4173	SHEET 4 OF 4					
APPROVED	TITLE	SCALE					
DE APPR.	POD RADALT MOUNTING	PLATE NTS					
DATE 10.09.01	COPYRICHT IS 2010 BY BART AER HIS INCUMENT IS PRIVATE INFORMATION, AND IS SEPTEMBED IN ARE TO BE UND FAR ARE PROPOSED IN SOMEWING COMMERCIALS	COSPACE LTD THE EXPRESS CONCERNMENT DISC					

D.

W/O:			WORK ORDER CHANGES									
DATE	STEP	PRO	OCEDURE CHANGE By			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
								Prod Wgr				
Part No		PAR #:	Fault Cat	tegory:	NCR: Yes	No DQ	A:	Date:				
					QA: N/C Closed: Date:							
NCR:			WORK ORI	DER NON-CONFORMA	NCE (NCF	R)						
DATE	STEP	Description of NC	Description of NC Corrective Action			Verifi	cation	Approval	Approval			
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Sect	ion C	Chief Eng	QC Inspector			

DART AEROSPACE LTD	Work Order:	61880
Description: Pod RADALT DOWNER	Part Number:	D4173-3
Inspection Dwg:D 4173-3 Rev: pA		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	x	First Artic	le	Proto	type		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
J. 701	1005-001	205	Ng.		V BOZ		
388	4010	,294	7	*	V		
1.300	4- 010	1.304	>		V		
7.004	4 00	7.026	7		V		
3512	4 .00	3,517	×		V		
363	4- 1016	-361	>		V		
1.378	4010	1.378	7		V		
4.620	4 2010	4.618	×		V		
2.310	4 .010	3.308	7		V		
7.88	4. 030	7.873	7		V		
9.63	130	9.638	>		V		
,88	4- 30	188.	7		V		
5,63	4/	5.676	>	1	Υ		
7.38	المري الم	7.379	7		V		
200,	1/010	ale	Y		V		
							34
		2					
Measured by:	B	Audited by:	8		Prototype Ap		N/A
Date:	10-9-13	Date:	10/01/13			Date:	N/A
Rev Date	Change	mspector to	PAI Dy	only	Rev	vised by	Approve

KJ/JLM

Change

New Issue

Rev

Date

Dart Aerosp	ace Ltd
-------------	---------

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	OCEDURE CHANGE By			Date	Qty	Approval Chief Eng /	Approval QC Inspector			
								Prod Mgr				
Part No	:	PAR #:	Fault Cate	egory:	NCR: Yes	No DQ	A:	_ Date: _				
Resolution:			Disposition: Q			osed:	Date: _					
NCR:		1	WORK ORD	ER NON-CONFORMA	ANCE (NCF	?)						
DATE	CTED	Description of NC	Description of NC Corrective Action				cation	Approval	Approval			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		tion C	Chief Eng	QC Inspector			

D4173-041 POD RADALT MOUNTING PLATE ASSY D4173-3 POD RADALT DOUBLER PRELIMINARY ISSUE REVISED GROOVE IN D4173-7: ADDED TOL ON D4173-7 THICKNESS MB 10.09.15 PA1 NEW ISSUE MB 10,09.01 REV. DESCRIPTION BY DATE DESIGN DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWN DRAWING NO. CHECKED D4173-7 RADALT SCHIM REV. PA2 D4173 MFG. APPR. SHEET 1 OF 7 APPROVED POD RADALT MOUNTING PLATE ASSY NTS DE APPR. DATE 10.09.01

Dart	Aerospa	ce Ltd
Duit	ACIOSPU	OC LIG

W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
								Prod Mgr	
									
Part No		PAR #:							
	R	esolution:						Date: _	
NCR:		\	WORK ORE	DER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Section		Verif	ication	Approval	Approval QC Inspector
DATE	SIEF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sec	tion C	Chief Eng	

7,024 1,300 3.512 PITCH 0.313 0.363 TYP TYP 0 0 1.378 R0.05 0 4 PL 7.38 5.63 4.620 0 0 2.310 PITCH C 0 **(** D4173-3 BXXXXX 0.88 Ø0.201 0 0 TYP 0.063 R0.93 REF 0.88 7,88 4 PL 9.63 **D4173-3 POD RADALT DOUBLER** PRELIMINARY ISSUE NOTES:
1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M606176S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.16 lbs DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. PA2 D4173 MFG. APPR. SHEET 5 OF 7 APPROVED TITLE SCALE POD RADALT MOUNTING PLATE ASSY NTS DE APPR COPYRIGHT © 2010 BY DART AEROSPACE LTD DATE 10.09.01

Dart Ae	rospace	Ltd								
W/O:			W	ORK ORDER CHAI	NGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No		PAR #:								
NCR:			WORK ORE	ER NON-CONFOR	MANCE	(NCR)			
DATE	STEP Description of NC Section A		Initial Chief Eng	Corrective Action S Action Description Chief Eng	Section B	Sign &		cation ion C	Approval Chief Eng	Approval QC Inspector

7.024 -- 1,300 3.512 PITCH 0.313 --9.000 0.363 0 0 R0.05 0 4 PL 4.620 0 7.38 5.63 6.650 0 2 310 PITCH 0 D4173-3 BXXXXX Ø0.201 0.88 0 0 TYP 0.063 R0.93 REF 0.88 4 PL 9.63

D4173-3 POD RADALT DOUBLER

NOTES

1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.063

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3

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5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX 6) IDENTIFICATION: PER QSI 044 6.1 7) WEIGHT: 0.16 lbs

8

D

DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA DRAWING NO. CHECKED REV. A D4173 MFG. APPR SHEET 5 OF 8 TITLE APPROVED SCALE POD RADALT MOUNTING PLATE ASSY NTS DE APPR COPYRIGHT © 2010 BY DART AEROSPACE LTD DATE 10.09.01

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